











<b>Customer</b>	: CU-DAR001* Dart Helicopters Services	<b>Drawing Name</b>	: SIDE (RH)		
<b>Job Number</b>	: 43112				
<b>Estimate Number</b>	: 10890				
<b>P.O. Number</b>	:	<b>Part Number</b>	: D32542		
<b>This Issue</b>	: 13/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b>	: D3254 REV A		
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A		
<b>First Issue</b>	: / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b>	: A		
<b>Previous Run</b>	: 43112	<b>Material</b>	:		
<b>Written By</b>	: _____	<b>Due Date</b>	: 20/11/2008	<b>Qty:</b>	2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: <u>JLO 08.11.13</u>				
<b>Comment</b>	: Est. B 04.10.26 D3254-2 no longer made in-house est c 08.11.13 in-house EC verified by:DD				

## Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
 		
<b>Comment:</b> Qty.: 3.5385 sf(s)/Unit Total : 7.0770 sf(s) 2024-T3 .063 sheet Batch: <u>109 463</u> <u>HB 8-11-13</u>		
2.0	WATER JET	FLOW WATER JET
 		
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3254 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> <u>HB 8-11-13</u>		
2-Deburr if necessary <u>HB 8-11-13</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-11-13</u>		
4.0	QC8	SECOND CHECK
 		
<b>Comment:</b> SECOND CHECK <u>S 08/11/18</u> <u>(42)</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
 		
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 <u>Bend as per dwg D3254</u> <u>HB 08/11/18</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 13/11/2008 9:08:38 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE (RH)

Job Number: 43112

Part Number: D32542

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/11/18 (12)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

22

08-11-18 x2

8.0

POWDER COATING

POWDER COATING



M10S642



(2X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30  
3200°F  
4:00

M-L 08/11/19

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 08/11/20 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 1-16

8/11/20

(2X)

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/24

Job Completion



MF 08-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43112	
<b>Description:</b> Side (Dual Battery Rack)		<b>Part Number:</b> D3254-2	
<b>Inspection Dwg:</b> D3254 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                 
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.20	+/-0.030	5.21	X			
4.15	+/-0.030	4.153	X			
R0.19	+/-0.030	.19	X			
1.103	+/-0.010	1.103	b			1.095 -> Acceptable
0.300	+/-0.010	.300	X			
Ø0.098	+0.005/-0.000	.101	X			
1.300 Pitch	+/-0.005	1.299	X			
21.056	+/-0.010	21.056	X			
19.000	+/-0.010	19.000	X			
1.003	+/-0.010	1.063	X			
Ø1.125	+0.005/-0.000	1.125	X			
5.403	+/-0.010	5.400	X			
Ø1.500	+0.005/-0.000	1.501	X			
2.750 Pitch	+/-0.005	2.746	X			
5.500	+/-0.010	5.496	X			
1.653	+/-0.010	1.655	X			
3.75	+/-0.030	3.747	X			
10.810	+/-0.010	10.807	X			
8.00	+/-0.030	7.985	X			
R0.50	+/-0.030	.50	X			
2.750 Pitch	+/-0.005	2.747	X			
4.125	+/-0.010	4.125	X			
22.946	+/-0.010	22.946	X			
R0.30	+/-0.030	.30	X			
9.90	+/-0.030	9.90	X			
11.77	+/-0.030	11.77	X			
1.82	+/-0.030	1.829	X			
2.17	+/-0.030	2.171	X			
20.10	+/-0.030	20.10	X			
0.953	+/-0.010	.955	X			
R0.125	+/-0.010	.125	X			
Grain along 20.10	N/A					

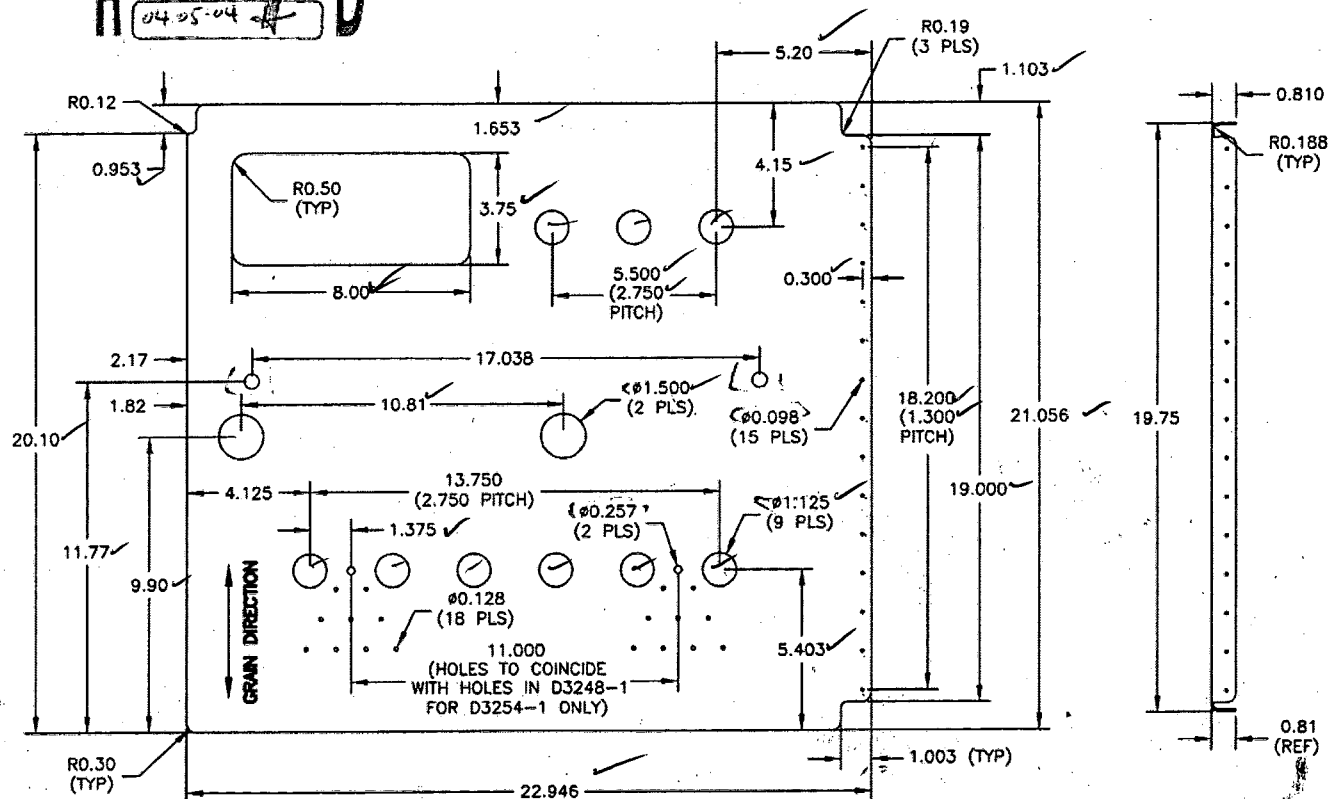
<b>Measured by:</b> LB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-11-13	<b>Date:</b> 08/11/14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	

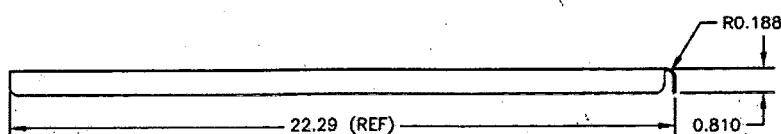


DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D3254	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE SIDE (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	

RELEASED  
04-05-04

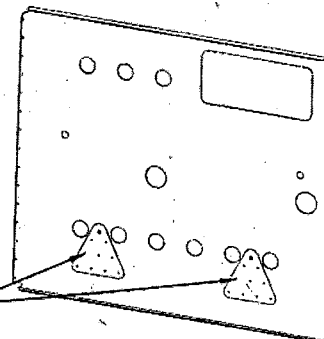


**D3254-1/-2 FLAT PATTERN**



**D3254-1 BEND DETAIL (SHOWN)  
D3254-2 OPPOSITE**

INSTALL D3248-1  
USING MS20470A4-5  
RIVETS



**D3254-041** SHOP COPY

RETURN TO:

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 4315

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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